

Work Order ID 142624

Friday, March 11, 2016 9:56:59 AM

Page 1

646.3311

B 142624

REV. N/C3

142624

Item ID: 646.3311

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: RH Half - Upper Cutter Assembly

Start Date: 4/18/2016 Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/6/2016 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MCS Date: MAR 11 2016

Tooling:

Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
646.3300	N/C3								

110

0.09

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.74

HAAS CNC vertical machine #1

1-Machine per folio FB154

DWG REV: N/C

FOLIO REV: AA

Blank 13.375

2- deburr and break all sharp edges

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

DAS

20

9-89

DAS

45

9-89

2016-05-15

DAS

20

9-89

2016-05-13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

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Page 2

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run	Start	*NR1*
	Stop	*NR2*

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 142624

Friday, March 11, 2016 9:56:59 AM

142624

Page 3

Item ID: 646.3311

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: RH Half - Upper Cutter Assembly

Start Date: 4/18/2016 Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/6/2016 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
155	QC5- Inspect part completeness to step on W/O	0.00							
155									
QC	Memo	0.00				(12)			DAS 38 9-88 MAY 25 2016
Quality Control									
180	Identify as per dwg & Stock Location: <u>CCF022</u>	0.00							
180									
Packaging	Memo	0.00				12			DAS 6 9-88 MAY 25 2016
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							16/5/26 J
Quality Control									

MCS MAY 26 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Picklist Print

Friday, March 11, 2016 9:56:59 AM

Page 1

Work Order ID: 142624

142624

Parent Item: 646.3311

646.3311

Parent Item Name: RH Half - Upper Cutter Assembly

Start Date: 4/18/2016

Required Date: 5/6/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 12/11/27 JFS VERIFY BY: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6B7.000X2.000		Purchased	No				f	35.4100		14.08421			DAS
M7075T6B7 000X2 000									**	14 13.375'		20 9-89	16-05-09
7075-T6 BAR 7.000" X 2.000" (order in billets - 13.375")													

Location	Loc Qty	Loc Code
MAT001	12.26	
m134175	12.26	
MAT024	23.15	
m133238	12	
m133886	11.15	

12.260'

1.115'

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																													
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<table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th colspan="3" style="text-align: left;">Root Cause</th> <th colspan="3" style="text-align: left;">FAULT CATEGORY</th> </tr> </thead> <tbody> <tr> <td style="width:15%;">Environment ☐</td> <td style="width:15%;">No Re-verification ☐</td> <td style="width:15%;">Pressure/Forced ☐</td> <td style="width:15%;">Temperature/Cure ☐</td> <td style="width:15%;">Power Loss/Surge ☐</td> <td style="width:15%;">Positioned Wrong ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td>Bending ☐</td> <td>Set-up ☐</td> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td>Centre Not Concentric ☐</td> <td>BOM/Route ☐</td> <td>Grain ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td>Cracks ☐</td> <td>Broken/Damage/Defect ☐</td> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td>Crimp/Kink/Ripple/Wave ☐</td> <td>Inspection Incomplete/Unqualified ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Cuffs ☐</td> <td>Contamination ☐</td> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Crushing ☐</td> <td>Countersink ☐</td> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> <td>Cut Too Short ☐</td> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Wave/Twist in Tube ☐</td> <td>Instructions Incomplete/Unclear ☐</td> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>Marks/Chatter ☐</td> <td>Drill Holes ☐</td> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td colspan="4" rowspan="2" style="text-align: center; vertical-align: top;"> OTHER : ☐ </td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> </tr> </tbody> </table>						Root Cause			FAULT CATEGORY			Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐				Misidentified ☐	Past Due ☐
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DART AEROSPACE LTD	Work Order:	142 624
Description: RH Half	Part Number:	646.3311
Inspection Dwg: 646.3300 Rev: NTC2 NTC3 <i>ASD</i>		Page 1 of 1

[illegible]

Rev	Date	Change	Revised by	Approved
A	13 09 17	New Issue	KJ	

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

04765

SHEET 1 OF 1

DWG NO. 646.3300

REV: NC

PREPARED
BY

J. SOTO

DATE: 12/08/2014

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: UPPER CUTTER ASSY

APPROVED BY:

ENGR

MFG

QC

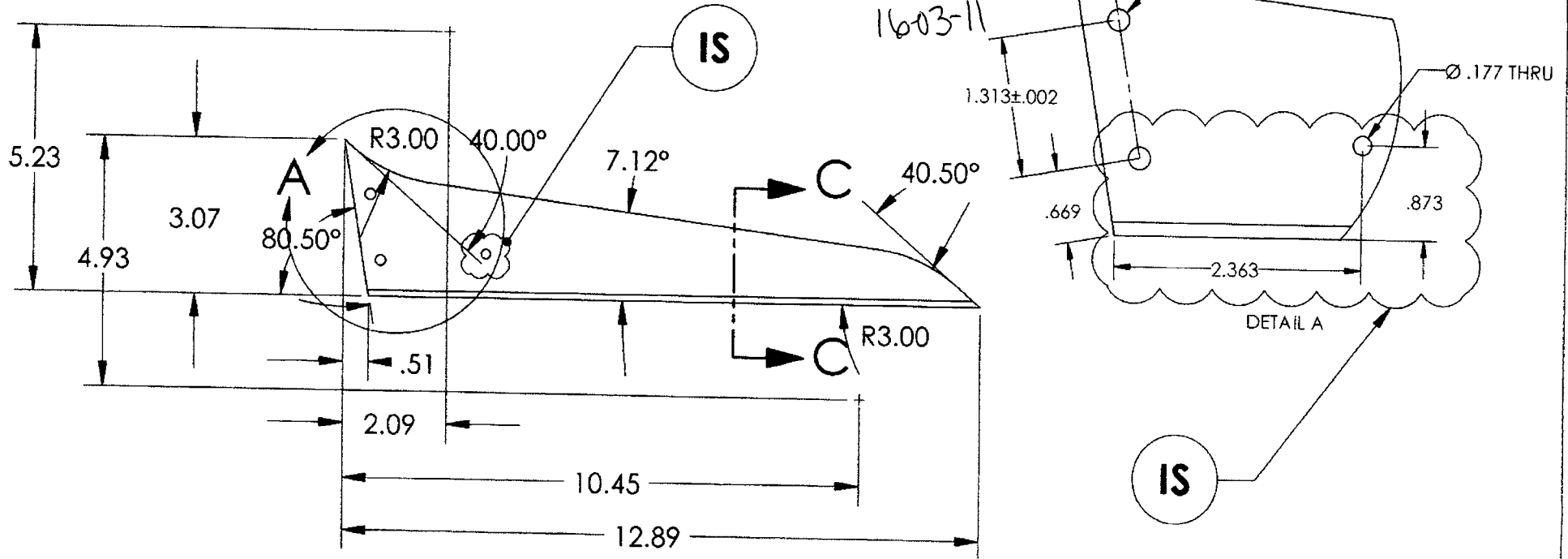
EFF. NEXT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: ADDED HOLE DIMENSION TO 646.3313.

SHEET 5 IS:

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 142624 MC



DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

☐ YES ☒ NO

APICAL
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 03724

SHEET 1 OF 1

DWG NO. 646.3300

REV: N/C

PREPARED
BY B. PETERS

DATE: 12/05/12

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: UPPER CUTTER ASSY

APPROVED BY: ENGR *[Signature]*

MFG *[Signature]*

QC *[Signature]*

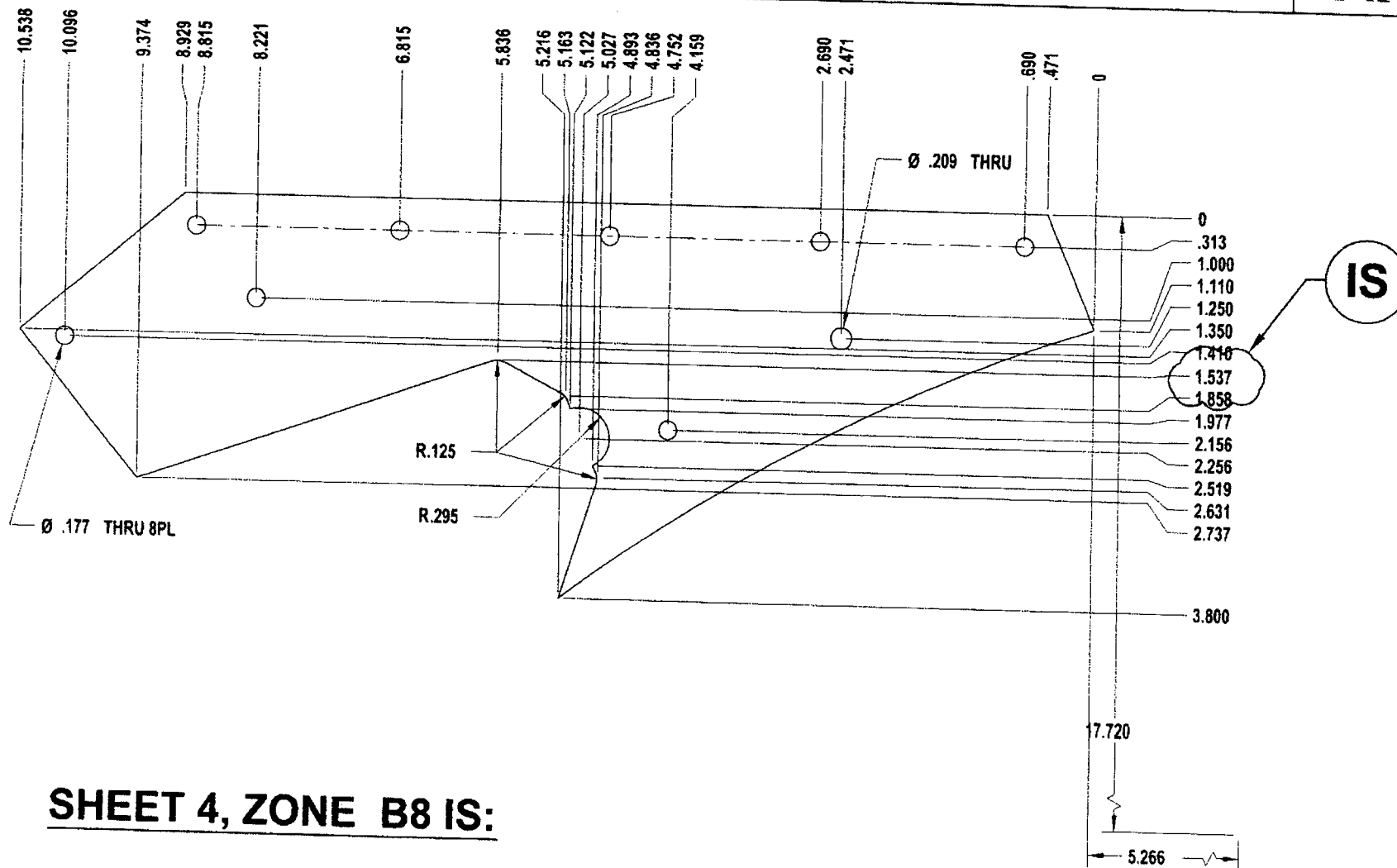
EFF: NEXT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON:

REVISED ORDINATE DIMENSION.

ECR:
D-12-025



SHEET 4, ZONE B8 IS:

DOCUMENTS EFFECTED:

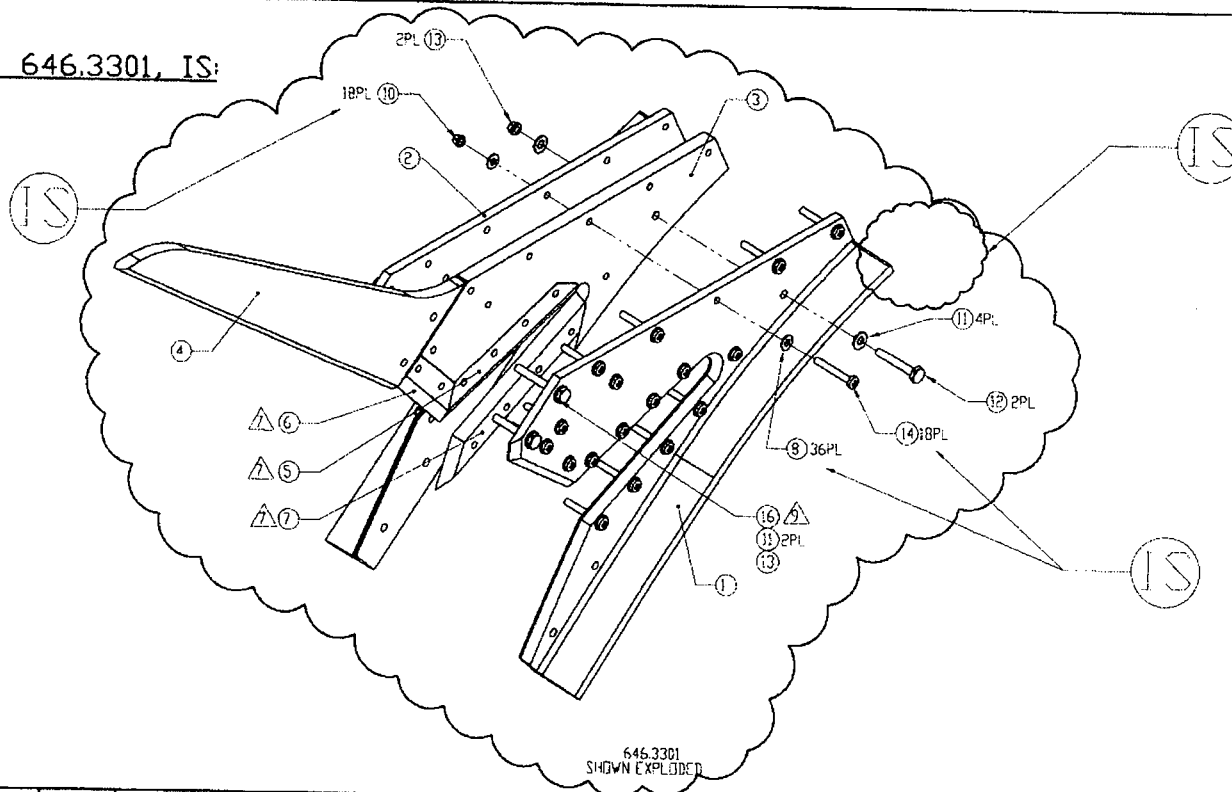
☐ RFMS ☐ MDL ☐ INSTALL INSTRUC ☐ ICA ☐ BOM

CHANGE CATEGORY
☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED
☐ YES ☒ NO

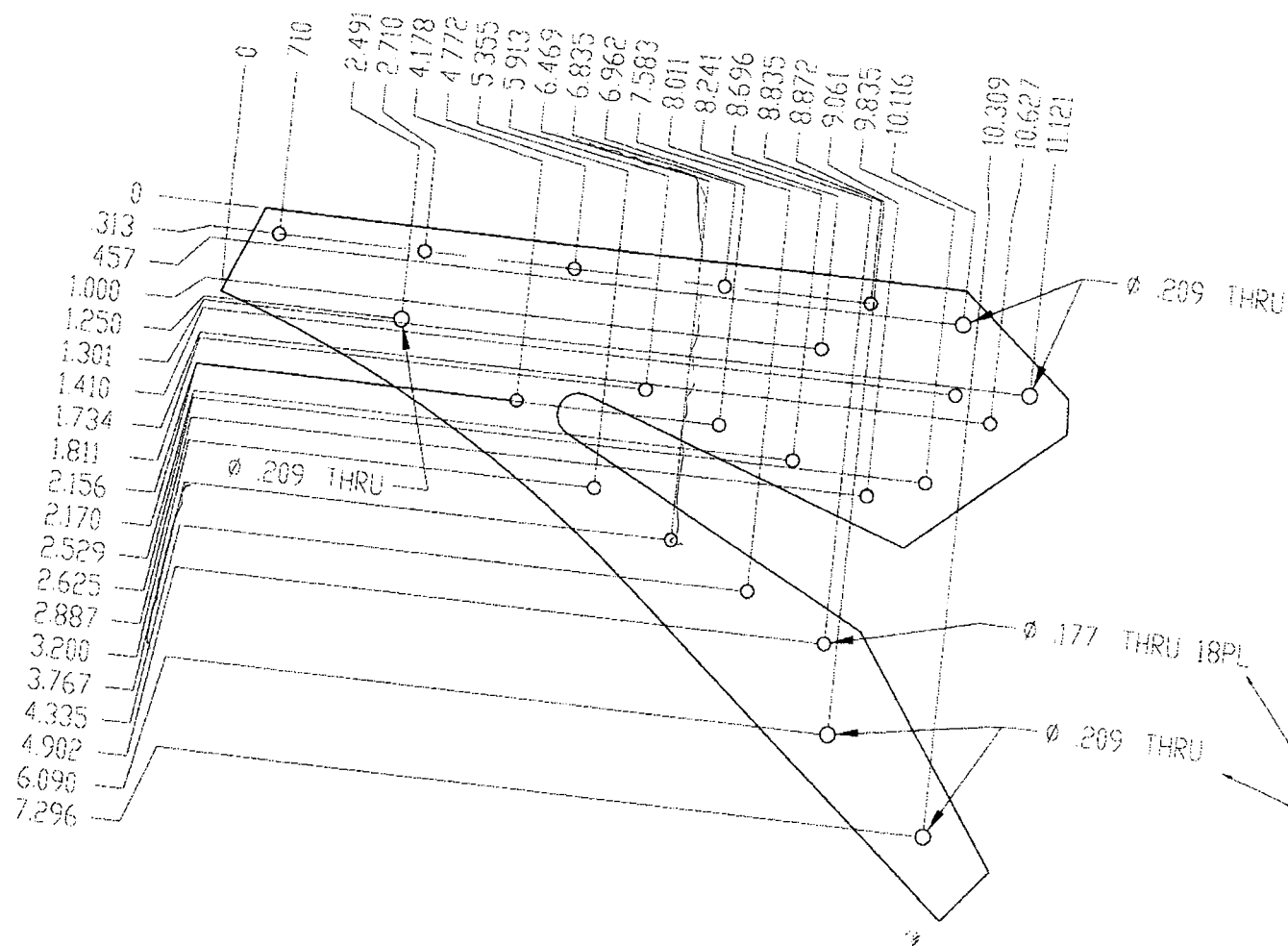
APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 02196		SHEET 1 OF 2	
	DWG NO. 646.3300	REV: N/C	PREPARED BY S. HUFF	DATE: 01/05/09
	DWG TITLE: UPPER CUTTER ASSY EFFECT ON DWG ☐ INC. ☒ UNINC.			
APPROVED BY: ENGR <i>[Signature]</i>		MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER
TRANSACTION CODES (TC) A-ADD C-CREATE R-REVISE D-DELETE		REASON: REMOVED RIVETS IN FAVOR OF ADDITIONAL SCREWS		

SHEET 1, VIEW 646.3301, IS:



14	R	601.2765	18	SCREW	MS27039-0819
10	R	601.1541	18	LOCKNUT	MS21042L08
9	D	601.2766	3	RIVET	MS20470AD5-18
8	R	601.2764	36	WASHER	NAS1149FN832P
			.3301		
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED:				☐ MDL ☒ INSTALL INSTRUC ☒ ICA ☐ FMS ☒ BOM	CHANGE CATEGORY ☐ MAJOR ☒ MINOR
				DER REVIEW REQUIRED ☐ YES ☒ NO	

SHEET 3, SECTION VIEW A-A, IS:



SECTION A-A

PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
-------------	-----	-------------	------------------------

REVISIONS			
REV	DISCRIPTION	DATE	APPROVED



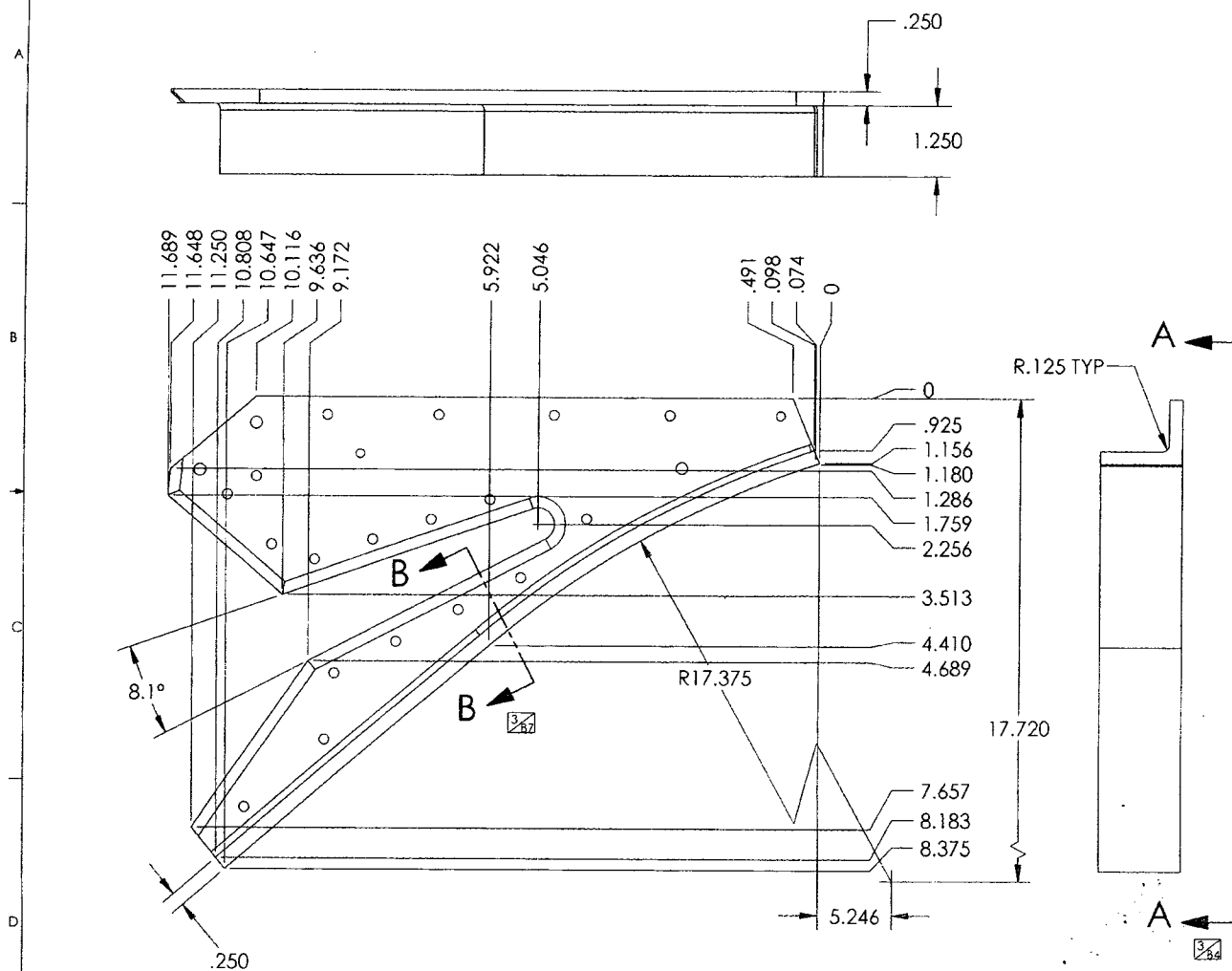
02196, 03724, 04765

 INSTALL FASTENER FINGER-TIGHT

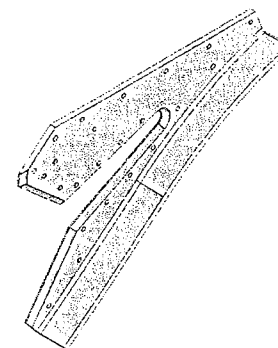
646.3301
SHOWN EXPLODED

[illegible]

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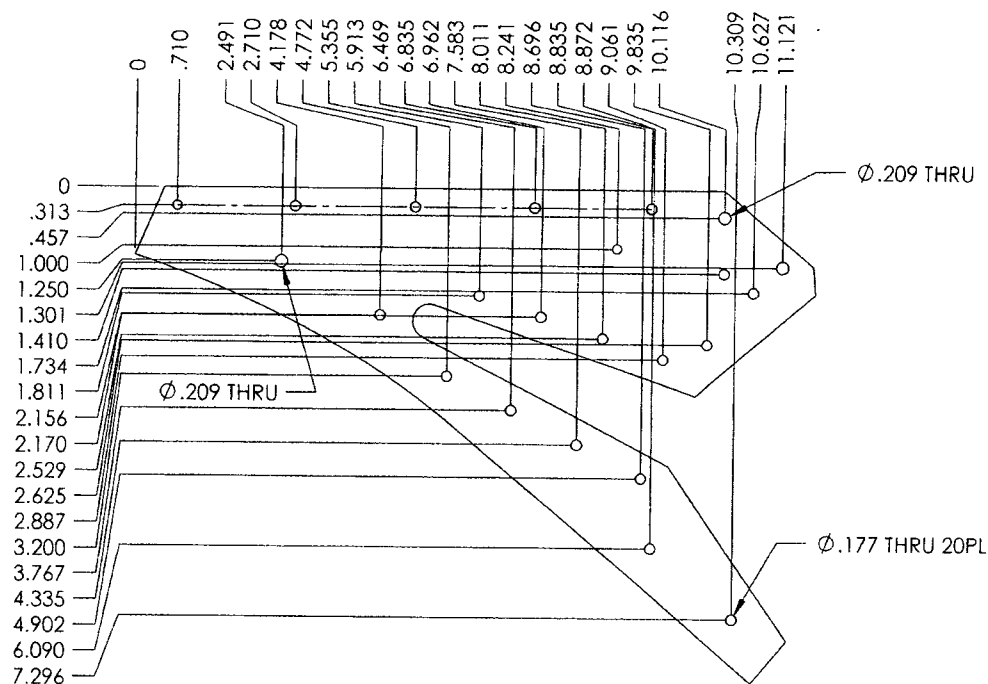


646.3310 SHOWN
646.3311 OPPOSITE

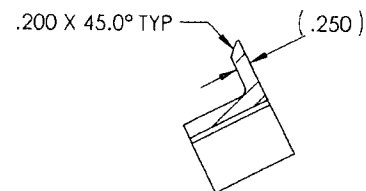


GREGGIAN DATE JULY 24 1974 08 24 08 DAY/MON/YR 5-1481 FRYA VO DRAWING APPROVAL FRYA VO CONTRACT NO.	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300 UPPER CUTTER ASSY ALL DIMENSIONS SPECIFIED UNLESS NOTED ARE REACHES 1. REACHES 4.5 2. REACHES 6.0 3. REACHES 6.5 4. REACHES 7.0 5. REACHES 7.5 6. REACHES 8.0 7. REACHES 8.5 8. REACHES 9.0 9. REACHES 9.5 10. REACHES 10.0 11. REACHES 10.5 12. REACHES 11.0 13. REACHES 11.5 14. REACHES 12.0 15. REACHES 12.5 16. REACHES 13.0 17. REACHES 13.5 18. REACHES 14.0 19. REACHES 14.5 20. REACHES 15.0 21. REACHES 15.5 22. REACHES 16.0 23. REACHES 16.5 24. REACHES 17.0 25. REACHES 17.5 26. REACHES 18.0 27. REACHES 18.5 28. REACHES 19.0 29. REACHES 19.5 30. REACHES 20.0 31. REACHES 20.5 32. REACHES 21.0 33. REACHES 21.5 34. REACHES 22.0 35. REACHES 22.5 36. REACHES 23.0 37. REACHES 23.5 38. REACHES 24.0 39. REACHES 24.5 40. REACHES 25.0 41. REACHES 25.5 42. REACHES 26.0 43. REACHES 26.5 44. REACHES 27.0 45. REACHES 27.5 46. REACHES 28.0 47. REACHES 28.5 48. REACHES 29.0 49. REACHES 29.5 50. REACHES 30.0 51. REACHES 30.5 52. REACHES 31.0 53. REACHES 31.5 54. REACHES 32.0 55. REACHES 32.5 56. REACHES 33.0 57. REACHES 33.5 58. REACHES 34.0 59. REACHES 34.5 60. REACHES 35.0 61. REACHES 35.5 62. REACHES 36.0 63. REACHES 36.5 64. REACHES 37.0 65. REACHES 37.5 66. REACHES 38.0 67. REACHES 38.5 68. REACHES 39.0 69. REACHES 39.5 70. REACHES 40.0 71. REACHES 40.5 72. REACHES 41.0 73. REACHES 41.5 74. REACHES 42.0 75. REACHES 42.5 76. REACHES 43.0 77. REACHES 43.5 78. REACHES 44.0 79. REACHES 44.5 80. REACHES 45.0 81. REACHES 45.5 82. REACHES 46.0 83. REACHES 46.5 84. REACHES 47.0 85. REACHES 47.5 86. REACHES 48.0 87. REACHES 48.5 88. REACHES 49.0 89. REACHES 49.5 90. REACHES 50.0 91. REACHES 50.5 92. REACHES 51.0 93. REACHES 51.5 94. REACHES 52.0 95. REACHES 52.5 96. REACHES 53.0 97. REACHES 53.5 98. REACHES 54.0 99. REACHES 54.5 100. REACHES 55.0 101. REACHES 55.5 102. REACHES 56.0 103. REACHES 56.5 104. REACHES 57.0 105. REACHES 57.5 106. REACHES 58.0 107. REACHES 58.5 108. REACHES 59.0 109. REACHES 59.5 110. REACHES 60.0 111. REACHES 60.5 112. REACHES 61.0 113. REACHES 61.5 114. REACHES 62.0 115. REACHES 62.5 116. REACHES 63.0 117. REACHES 63.5 118. REACHES 64.0 119. REACHES 64.5 120. REACHES 65.0 121. REACHES 65.5 122. REACHES 66.0 123. REACHES 66.5 124. REACHES 67.0 125. REACHES 67.5 126. REACHES 68.0 127. REACHES 68.5 128. REACHES 69.0 129. REACHES 69.5 130. REACHES 70.0 131. REACHES 70.5 132. REACHES 71.0 133. REACHES 71.5 134. REACHES 72.0 135. REACHES 72.5 136. REACHES 73.0 137. REACHES 73.5 138. REACHES 74.0 139. REACHES 74.5 140. REACHES 75.0 141. REACHES 75.5 142. REACHES 76.0 143. REACHES 76.5 144. REACHES 77.0 145. REACHES 77.5 146. REACHES 78.0 147. REACHES 78.5 148. REACHES 79.0 149. REACHES 79.5 150. REACHES 80.0 151. REACHES 80.5 152. REACHES 81.0 153. REACHES 81.5 154. REACHES 82.0 155. REACHES 82.5 156. REACHES 83.0 157. REACHES 83.5 158. REACHES 84.0 159. REACHES 84.5 160. REACHES 85.0 161. REACHES 85.5 162. REACHES 86.0 163. REACHES 86.5 164. REACHES 87.0 165. REACHES 87.5 166. REACHES 88.0 167. REACHES 88.5 168. REACHES 89.0 169. REACHES 89.5 170. REACHES 90.0 171. REACHES 90.5 172. REACHES 91.0 173. REACHES 91.5 174. REACHES 92.0 175. REACHES 92.5 176. REACHES 93.0 177. REACHES 93.5 178. REACHES 94.0 179. REACHES 94.5 180. REACHES 95.0 181. REACHES 95.5 182. REACHES 96.0 183. REACHES 96.5 184. REACHES 97.0 185. REACHES 97.5 186. REACHES 98.0 187. REACHES 98.5 188. REACHES 99.0 189. REACHES 99.5 190. REACHES 100.0 191. REACHES 100.5 192. REACHES 101.0 193. REACHES 101.5 194. REACHES 102.0 195. REACHES 102.5 196. REACHES 103.0 197. REACHES 103.5 198. REACHES 104.0 199. REACHES 104.5 200. REACHES 105.0 201. REACHES 105.5 202. REACHES 106.0 203. REACHES 106.5 204. REACHES 107.0 205. REACHES 107.5 206. REACHES 108.0 207. REACHES 108.5 208. REACHES 109.0 209. REACHES 109.5 210. REACHES 110.0 211. REACHES 110.5 212. REACHES 111.0 213. REACHES 111.5 214. REACHES 112.0 215. REACHES 112.5 216. REACHES 113.0 217. REACHES 113.5 218. REACHES 114.0 219. REACHES 114.5 220. REACHES 115.0 221. REACHES 115.5 222. REACHES 116.0 223. REACHES 116.5 224. REACHES 117.0 225. REACHES 117.5 226. REACHES 118.0 227. REACHES 118.5 228. REACHES 119.0 229. REACHES 119.5 230. REACHES 120.0 231. REACHES 120.5 232. REACHES 121.0 233. REACHES 121.5 2
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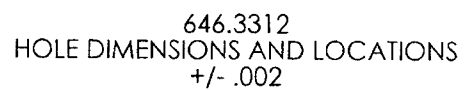
SECTION A-A



SECTION B-B

ORIGINAL DATE 11/20/01		APICAL INDUSTRIES	
DRAWN BY P. BRAY		2608 TEMPLE HEIGHTS DR.	
CHECKED BY P. BRAY		OCEANSIDE, CA 92056-3512 (760)724-5300	
DATE 11/20/01		UPPER CUTTER ASSY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1. FRACTIONS DECIMALS ±.01 2. DECIMALS ±.005 3. ANGLES ±.5°		REV. NO. 07/10/06	REV. N/C
SCALE NONE		SHEET 3 OF 8	

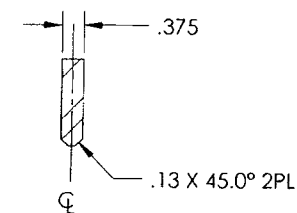
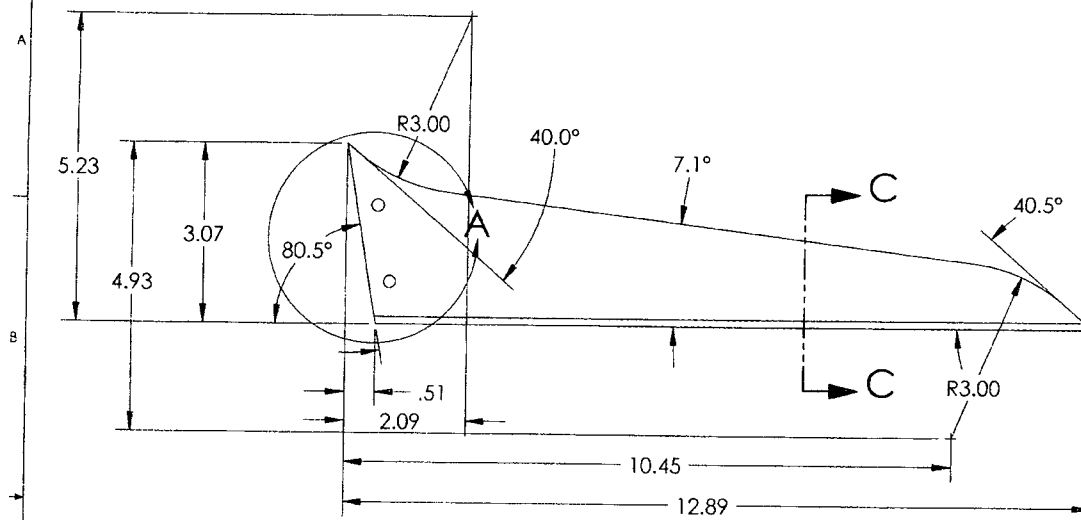
REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



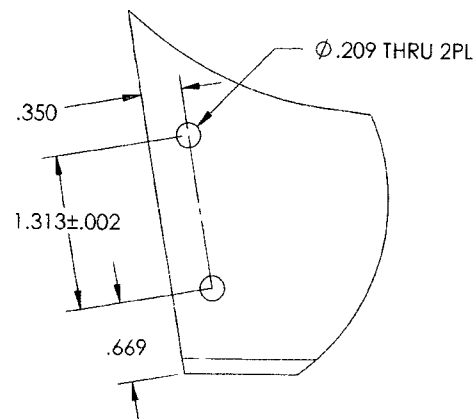
OFFICIAL DATE		08-25-06	
INVOICE #		004757	
CITY		MIDWINTER	
STATE		TX	
COUNTY		P. HAVCO	
APPROVAL		P. HAVCO	
DATE		08-25-06	
CONTRACT #			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE BY FACE UNLESS NOTED 1. PLACE DIMENSIONS 1/8" ON 2. PLACE DIMENSIONS 1/8" ON 3. PLACE DIMENSIONS 1/8" ON			
SHEET		PAGE NO.	
B		07/2M6	
SCALE		1" = 4'-0"	
FIGURE		5	
SHEET		4 OF 8	

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES AND REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

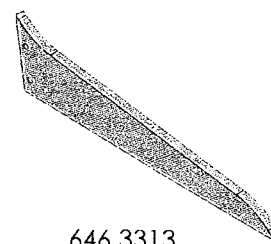
REVISIONS			
REV	DESCRIPTION	DATE	APPROVED TO



SECTION C-C



DETAIL A

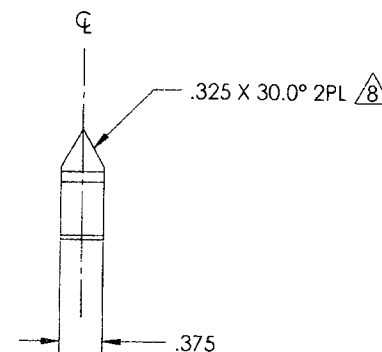
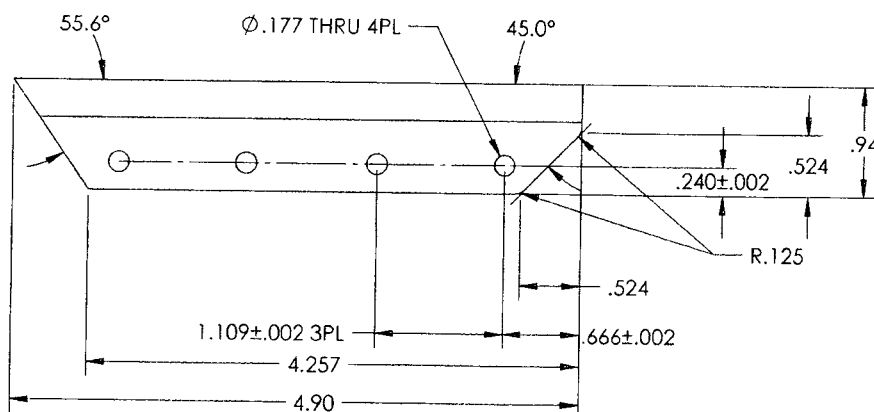


646.3313

ORIGINAL DATE: 08-20-08 MOD DATE: 08-20-08 DRAWN BY: J. HERR S. HERR P. SPANO DRAWING APPROVAL: P. SPANO 08-20-08 CHECKED BY:		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS: $\pm .01$ 3 PLACE DECIMALS: $\pm .002$ 4 PLACE DECIMALS: $\pm .0005$		SIZE: B SCALE: NONE	CAD CODE: 07M26 DWG NO: 646.3300 SHEET: 5 OF 6
REV: N/C		UPPER CUTTER ASSY	

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REVISED			
REV.	DESCRIPTION	DATE	APPROVED

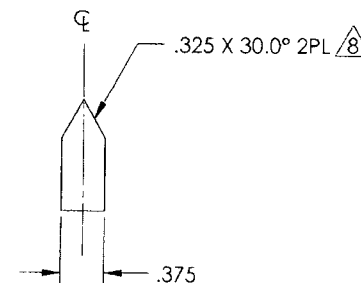
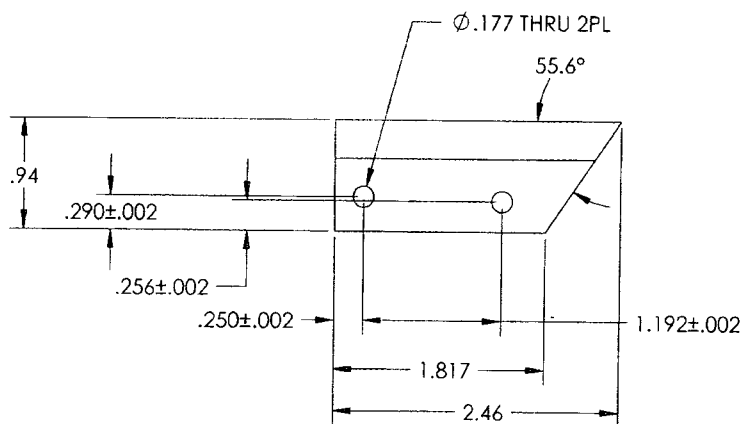
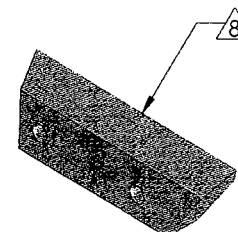


646.3314

ORIGINAL DATE: 08-26-90 LUD DA YR: 08-26-90 DRAWN BY: JCH/STP S. HUN P. STAVO DRAWING APPROVAL: P. BRADY DATE: 08-26-90 CONTRACT NO:		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
IF ALL SPECIFICATIONS SPECIFIED DIMENSIONS ARE IN INCHES DIMENSIONS ARE PLACE DECIMALS ±.01 PLACE DECIMALS ±.005 ANGLES = 5°		UPPER CUTTER ASSY	
REV. 8	CAGE CODE 07M16	QWC. NO. 646.3300	REV. N/C
SCALE NONE		SHEET 6 OF 8	

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APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT
THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

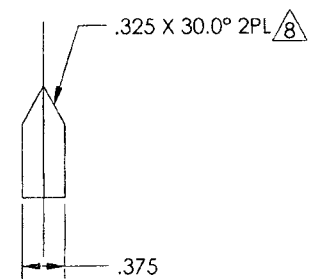
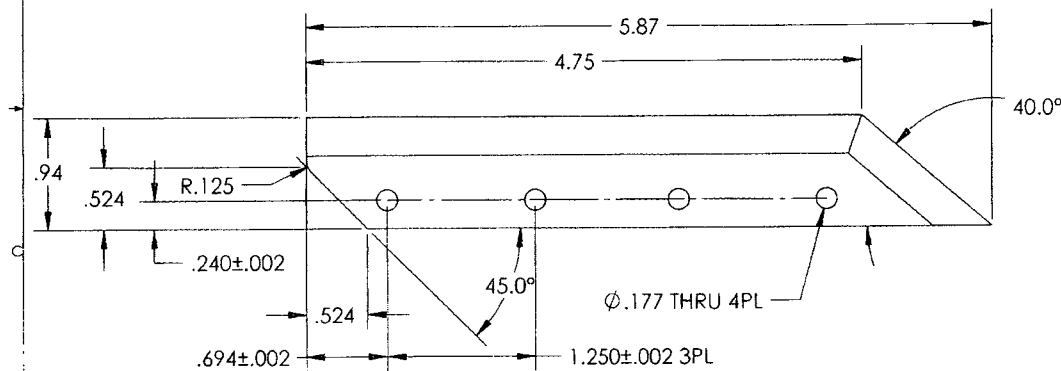
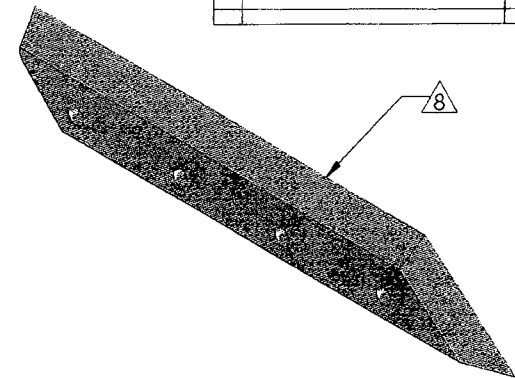


646.3315

DRAWING DATE: 08-24-20 DRAWING BY: J. HUFF DRAWING APPROVAL: J. BAIRD CONTRACT NO.		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.005 ANGLES ±.5°		UPPER CUTTER ASSY	
SHEET	CAL CODE 07M26	DWG NO 646.3300	REV N/C
SCALE NONE		SHEET 7 OF 8	

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

REVISION			
REV.	DESCRIPTION	DATE	APPROVED



646.3316

ORIGINAL DATE MOD DATE DRAWN BY CHECKED BY DESIGNED BY DRAWING APPROVAL P. BRAND 08-26-08 CONTRACT NO.	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300
UPPER CUTTER ASSY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES 1:32 DECIMAL ANGLES 2:64 DECIMAL ANGLES 3:128 DECIMAL ANGLES 4:256 DECIMAL ANGLES 5:512 DECIMAL ANGLES	REV N/C
SHEET 07M26 SCALE NONE	646.3300 SHEET 8 OF 8

Jean-Luc Menard

From: Pablo Bravo
Sent: Wednesday, March 09, 2016 12:01 PM
To: Jean-Luc Menard
Subject: RE: 646.3310/646.3311 DEVIATION

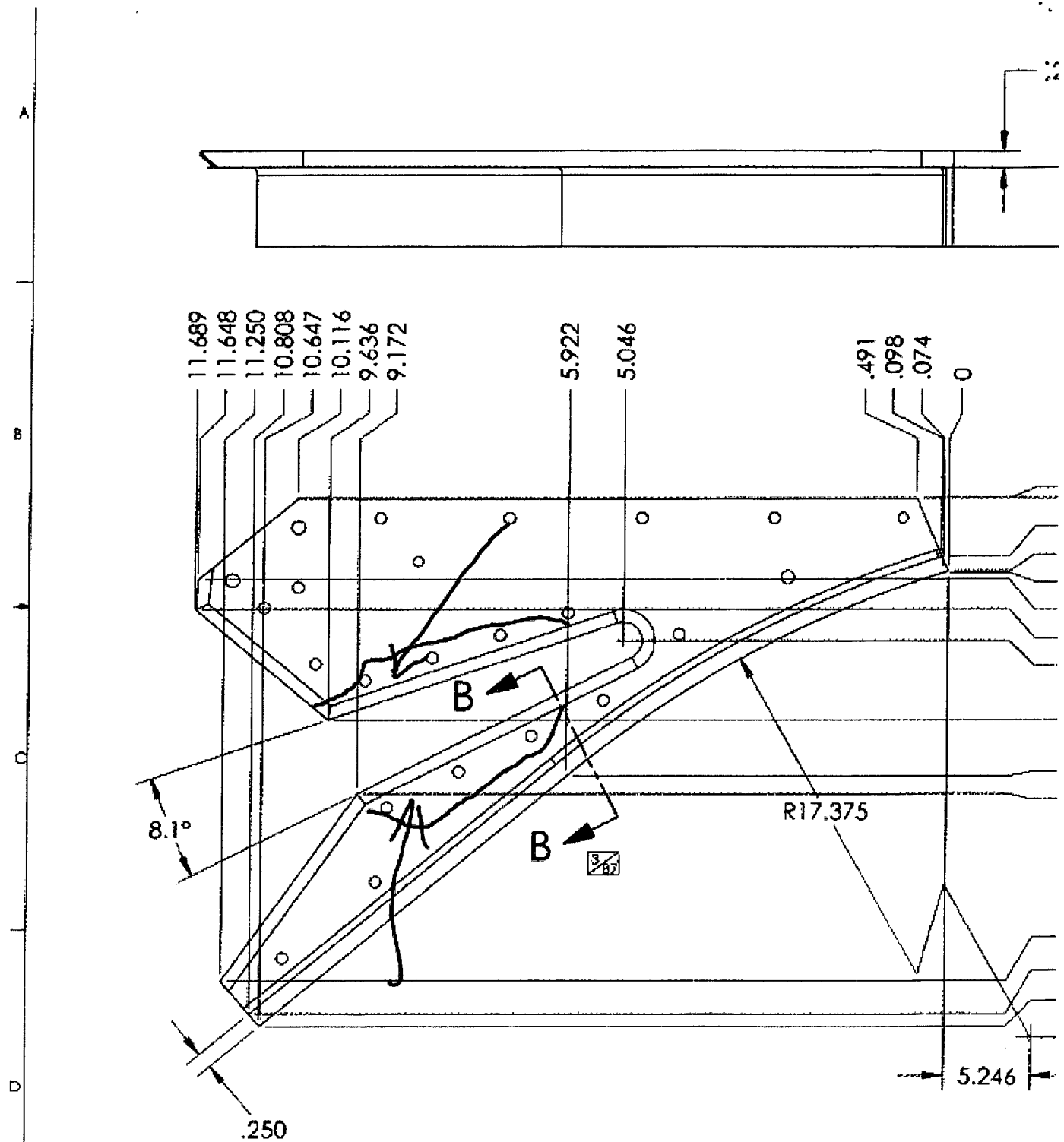
JL,

As long as the mating parts fit fine, this should be okay.

Pablo

From: Jean-Luc Menard
Sent: Wednesday, March 09, 2016 5:09 AM
To: Pablo Bravo
Subject: 646.3310/646.3311 DEVIATION

Hi Pablo,
WE have a part coming in at .242" in the area shown, is this deviation acceptable?
Thx
JL



646.3310 SHOWN
646.3311 OPPOSITE

Jean-Luc Menard
Production Engineering Supervisor

DART AEROSPACE
T 1 613 632-5200 > 227
F 1 613 632-5246
1 800 556- 4166
www.dartaerospace.com



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 911717

Date: 20-May-16

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

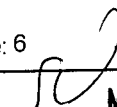
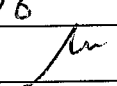
CHANTAL LAVOIE
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
	PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.		
3 ea	Part: D5155-043 CO-PILOT Job: 19533	PO: PO32413	Rev: B Line: 1
15 ea	Part: D5156-9 Back Plate Job: 19534	PO: PO32413	Rev: B Line: 2
10 ea	Part: D5156-5 Face Plate Job: 19535	PO: PO32413	Rev: B Line: 3
8 ea	Part: D5155-11 Co-Pilot Job: 19536	PO: PO32413	Rev: B Line: 4
12 ea	Part: 646.3311 RH Half Job: 19537	PO: PO32413	Rev: N/C Line: 5
12 ea	Part: 647.3910 Upper Deflector Job: 19538	PO: PO32413	Rev: C Line: 6
1 ea	Part: ADMINISTRATION FEE ADMINISTRATION FEE Job: 19539	PO: PO32413	Rev:  Line: 8
DATE: 20/5/16			
CERTIFIED SIGNATURE: 			

MAY 24 2016



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO32413**

Purchase Order Date 5/18/2016

PO Print Date 5/19/2016

Page Number 1 of 4

Order From :

VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

MAY 19 2016

E-MAILED

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	144951	D5155-043 CO-PILOT REV. B	5/24/2016 Yes 5/24/2016		3.00	\$3.47	\$10.41
FINISH: Black Anodize per MIL-A-8625F Type I or IB or IC or II or IIB Class 2							
RUSH ORDER REQUIRE ON TUESDAY MAY, 24 OR BEFORE							
Line Total:							\$10.41
2	143501	D5156-9 BACK PLATE REV. B	5/24/2016 Yes 5/24/2016		15.00	\$3.47	\$52.05
FINISH: Black Anodize per MIL-A-8625F Type I or IB or IC or II or IIB Class 2							
RUSH ORDER REQUIRE ON TUESDAY MAY, 24 OR BEFORE							
Line Total:							\$52.05

Note:

5/19/2016



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO32413**

Purchase Order Date 5/18/2016

PO Print Date 5/19/2016

Page Number 2 of 4

Order From :

VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

FCA - (Free Carrier)

3	145840	D5156-5 FACE PLATE REV. B	5/24/2016	10.00	✓	\$3.47	\$34.70
---	--------	------------------------------	-----------	-------	---	--------	---------

Yes

5/24/2016

FINISH: Black Anodize per MIL-A-8625F Type I or IB or IC or II or IIB Class 2

RUSH ORDER REQUIRE ON TUESDAY MAY, 24 OR BEFORE

Line Total: **\$34.70**

4	144595	D5155-11 CO-PILOT REV. B	5/24/2016	8.00	✓	\$3.48	\$27.84
---	--------	-----------------------------	-----------	------	---	--------	---------

Yes

5/24/2016

FINISH: Black Anodize per MIL-A-8625F Type I or IB or IC or II or IIB Class 2

RUSH ORDER REQUIRE ON TUESDAY MAY, 24 OR BEFORE

Line Total: **\$27.84**

5	142624	646.3311 RH HALF REV. N/C	5/27/2016	12.00	✓	\$18.10	\$217.20
---	--------	------------------------------	-----------	-------	---	---------	----------

Yes

5/27/2016

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE I CLASS N

Note:

5/19/2016



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO32413**

Purchase Order Date 5/18/2016

PO Print Date 5/19/2016

Page Number 3 of 4

Order From :

VC-ATG001

Ship To : DART AEROSPACE LTD

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Total: \$217.20

6	144768	647.3910 UPPER DEFLECTOR REV. C	5/27/2016	12.00	12.05	\$144.60
---	--------	------------------------------------	-----------	-------	-------	----------

Yes

5/27/2016

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE I CLASS N

Line Total: \$144.60

7	71401-45	PROCUREMENT QUALITY CLAUSES	5/24/2016	1.00	\$0.00	\$0.00
---	----------	--------------------------------	-----------	------	--------	--------

No

5/24/2016

Procurement Quality Clauses

A004 FAA-PMA /TSO

A005 RIGHT OF ENTRY

A016 PERSONNEL QUALIFICATION

A024 PROCESS CERTIFICATIONS

A025 CERTIFICATE OF CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENTS

Line Total: \$0.00

Note:

5/19/2016



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO32413**

Purchase Order Date 5/18/2016

PO Print Date 5/19/2016

Page Number 4 of 4

Order From :

VC-ATG001

Ship To : DART AEROSPACE LTD

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613-446-4544

Ship To Contact

Ship To Phone

Ship Via:

VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

8	71401-45	ADMIN FEE	5/24/2016	1.00	\$150.00	\$150.00
			No			
			5/24/2016			

Line Total: \$150.00

PO Total: \$636.80

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 2

Change Date: 5/19/2016

Chantal Lavoie

From: Roger Lebel <rlebel@atgindustries.com>
Sent: Thursday, May 19, 2016 2:11 PM
To: Chantal Lavoie
Subject: RE: PO32320

Salut Chantal,

Here's your
quote,

Part Number	Qty	Requirement	Unit Cost
D5155-043	3	BLACK ANODIZE	\$3.47
D5156-9	15	BLACK ANODIZE	\$3.47
D5156-5	10	BLACK ANODIZE	\$3.47
D5155-11	8	BLACK ANODIZE	\$3.48
646.3311	12	HARD ANO BLACK & PRIMER	\$18.10
646.3311	12	HARD ANO BLACK & primer	\$12.05
ADMIN	1		\$150.00

They should be ready for the 24th or earlier.

Merci!

Thank you/Merci!

Roger Lebel

Manager, Anodizing, & Painting Department
Director, Human Resources
www.ATGIndustries.com
Email: rlebel@atgindustries.com
Phone: (613) 446-4544
Fax: (613) 446-4556

From: Chantal Lavoie [clavoie@dartaero.com]
Sent: Thursday, May 19, 2016 7:46 AM
To: Roger Lebel
Subject: RE: PO32320

Sure thing .

Thank you,
Chantal

From: Roger Lebel [mailto:rlebel@atgindustries.com]
Sent: Thursday, May 19, 2016 6:40 AM
To: Chantal Lavoie <clavoie@dartaero.com>
Subject: PO32320

Salut Chantal,

Is it Ok if you receive PO32320 tomorrow morning? They are being painted right now. Someone can come to pick them up this afternoon but we usually wait 24 hours to let them dry appropriately.

Sorry about this.

Marc-André

Thank you/Merci!

Roger Lebel

Manager, Anodizing, & Painting Department
Director, Human Resources
www.ATGIndustries.com
Email: rlebel@atgindustries.com
Phone: (613) 446-4544
Fax: (613) 446-4556

From: Chantal Lavoie [clavoie@dartaero.com]
Sent: Wednesday, May 18, 2016 1:41 PM
To: Roger Lebel
Subject: NEW PO32413

Good afternoon Roger,
Please see attached for new po32413, Steven drop off the parts this morning.
Please advise if possible to get line #1,2,3,4, for next Tuesday May, 24.
Thanks
Chantal

Chantal Lavoie
Purchasing Coordinator

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